

# Work Order ID 54452

December 9, 2009 11:31:59 AM



Page 1

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 09/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: RP

Date: 12-12-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3512	Rev C								
100		0.00							
	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo 1-Cut as per Dwg D3512 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								
120		0.00							
	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

B 9-12-10

(12)

B 9-12-10

2780912/10

(411) P10 →

W/O: 54452

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/12/10	# 20	Took Qty x1 Part For QC inspection template	S	9/12/10	x1		S 09/12/10

Part No: D3512-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54452

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Revision ID:

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Item Name: Wearplate

Start Date: 09/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Deburr if necessary ☐ Form as per dwg D3512 using DT8179

5809/12/16

(11)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

5809/12/16

(4h)

150



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT8874 as per Dwg D3512 & OSI 004 ☐ Qty  
Description Batch ☐ A/R 2059b Hardcoat Rod H112963

EL/SR 09.12.17 (11x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54452



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Item ID: D3512-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 09/12/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC10- Inspect visual per QS1004- ground welds

0.00



2) Sorted 1/7

QC

Memo

0.00

14

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



2) Sorted 1/7

QC

Memo

0.00

11

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



M112 588

0.00

BR 09-12-17

Powdercoat

Memo

11

Powder Coating

START TIME: 1:50 □OVEN TEMPERATURE:  
3:20 □FINISH TIME: 2:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Item ID: D3512-1

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Revision ID:

Stop



Item Name: Wearplate

Start Date: 09/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00 = 7.44 09-12-17



QC

Memo

0.00

Quality Control

X11 0

200

Identify as per dwg & Stock Location: 50

0.00



Packaging

Memo

0.00

Packaging

9/12/17 sl (12) SP

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/18 48

0912-18 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

December 9, 2009 11:32:05 AM

Page 1

Work Order ID: 54452



Parent Item: D3512-1



Parent Item Name: Wearplate



Start Date: 09/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	400.6457	2.1979	<del>2.2</del> 5.		
											13 9-12-10	

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

400.6456737

106860

16.018

111924

25.1689737

112442

29.8899

112567

0.2973

112885

9.2715

113295

320

11288.5

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

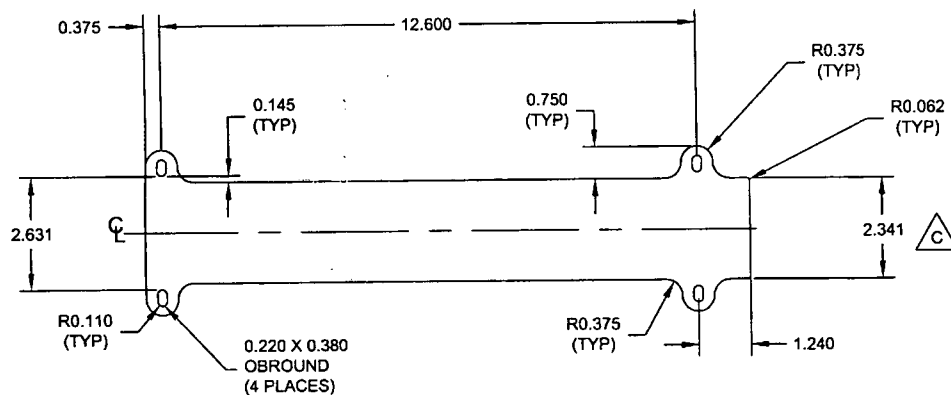
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

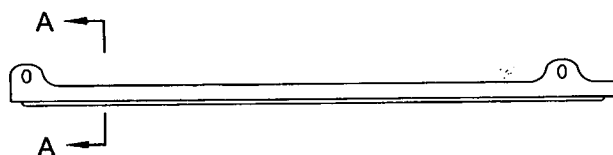
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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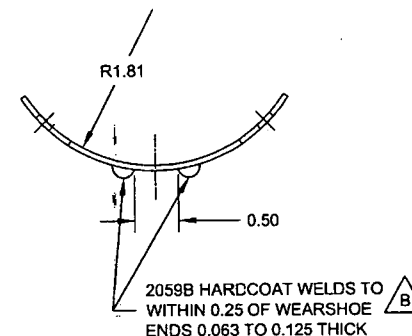




**D3512-1F FLAT PATTERN**



**D3512-1 BENDING DETAIL**



**SECTION A-A  
SCALE 2:3**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54452  
PL 0912-9

**RELEASED**  
07.11.16



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

C	ENLARGE OBOURD FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	07.10.05		

<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWING NO. D3512	REV. C SHEET 1 OF 1
TITLE WEARPLATE	SCALE 1:3

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